

# Work Order ID 61352

August 19, 2010 9:24:44 AM



Page 1

Item ID: D205-634-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Replacement Skidtube

Start Date: 8/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/06/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CG Date: 10/8/19 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2580

Rev D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG002

N/A *[Signature]*

110

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

1-Bend as per program D2580.C on CNC Bender and Folio 16

2-Cut tubes as per Dwg. D2580

3- scribe batch# in aft end of tube

*[Signature]* 10-9-14

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Skidtubes

Memo

0.00

Skidtubes

1- Deburr ends

2- C'sink holes as per dwg without cutting fluid

3- Prepare tube for welding, remove alodine as required.

4- Scribe batch number insied aft end of tube.

BB 10/09/15

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 - BE 10/09/15

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Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Weld step D2576 as per Dwg. D2580 and QSI 004  
A/R□□□ Aluminum Rod

2-Prep per QSI 005 and weld crossbolt spacers D2579 as per Dwg. D2580, QSI 004.

For D2579 spacers, weld one side, pass 3/8" drill, weld other side, pass 3/8" drill  
A/R□□□ Aluminum Rod

3-Grind welds as per Dwg D2580 Grind flush ridge made from bending

4-Drill holes for wearplates using DT 8217 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

5-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2580. Deburr holes

6-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr

7-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

BE 10/09/15

BE 10/09/15

DD 10/9-22  
BB 10/09/22

DD 10-9-23

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Item ID: D205-634-041

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00 0.00 8/10/09/23							
160  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00 8/10/09/23				(X)			
170  HandFinish Hand Finishing	Pressure Wash per QSI005 4.3  Memo Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.	0.00 0.00 8/10-9-27							①. φ.

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Item Name: Replacement Skidtube

Start Date: 8/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/06/10 Req'd Qty: 1.00

Customer:

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Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

10-9-28

M115291

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:45  
320°  
9:15

0.00

①

190



QC

Quality Control

QC3- Inspect Part Finish

0.00

=> 10109129

Memo

0.00

1 9

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Required Date: 9/06/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

0.00

=) *Y* 10/09/29

1

Ø

HandFinish

Memo

0.00

Hand Finishing

1-Install inserts &amp; wearplates &amp; Gaskets as per Dwg. D2580. Use a drop of

Sikaflex on insert holes before installing wearplates

A/R ☐☐☐ Sikaflex-291 *M11511* ☐☐Sikaflex expire date: *11/01*

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step &amp; Aft Cap with

Sikaflex. Clean excess adhesive

A/R ☐☐☐ Sikaflex-291 *M11511* ☐☐Sikaflex expire date: *11/01*

5-Wing Walk as per Dwg D2580 and QSI 005 4.4

Batch: *M115029*

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Start Date: 8/19/10 Start Qty: 1.00



Cust Item ID:

Required Date: 9/06/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC5- Inspect part completeness to step on W/O

0.00

8/10/08/29



QC

0.00

Memo

Quality Control

Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

70

220

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-634-041

Location: \_\_\_\_\_

PPP Rev: PPP 6/3/22

8/10/08/18

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/08  
MK  
10-10-08

# Picklist Print

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Work Order ID: 61352



Parent Item: D205-634-041



Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD  
 IPP Rev. O 06.02.28 Added paperwork EC  
 IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2580-1		Manufactured	No			110	Each	5.0000	4	1			
205 Skidtube bent detail													

Location	Loc Qty	Loc Code
LG	4	①
57028	1	
60956	1	
61191	2	
ST046	1	
59856	1	

*DP 10-9-14*

D2576-3		Manufactured	No			140	Each	84.0000	1	1			
Step (maching detail)													

Location	Loc Qty	Loc Code
LG	84	
46661	36	
52215	48	

*BE 10-09-15*



# Picklist Print

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Work Order ID: 61352

Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

D2579 Manufactured No 140 Each 295.0000 20 20



Crossbolt Spacer

Location	Loc Qty	Loc Code
LG	295	
57052	5	
57348	4	
58433	2	
59113	182	
60845	102	

D2855 Manufactured No 200 Each 77.0000 1 1



Cap

Location	Loc Qty	Loc Code
FP6	1	
56613	1	
ST026	76	
50513	1	
50770	28	
51539	2	
53791	45	

AN3-5A Purchased No 200 Each 1,534.000 2 2



Bolt

Location	Loc Qty	Loc Code
ST350	1534	
105057	534	
115016	500	
115371	500	

20 BE 10/09/15

YJ 10/09/29

X1  
YJ 10/09/29

X2

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Shop Packet Print

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# Picklist Print

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Parent Item: D205-634-041

Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD10L NAS1149D0332J Purchased

No

200

Each

2,623.000

2

2



YH 10/09/29

Washer

## Location

## Loc Qty

## Loc Code

ST348

2623

110985

2623

M114348

X2

ALS7-1032-130

Purchased

No

200

Each

878.0000

50

50



YH 10/09/29

Insert

## Location

## Loc Qty

## Loc Code

FP

861

115079

861

M114723

X50

ST282

17

113238

17

AN3C4A

Purchased

No

200

Each

1,991.000

50

50



YH 10/09/29

BOLT

## Location

## Loc Qty

## Loc Code

ST303

500

115438

500

ST350

1491

114108

14

114416

12

114523

2

114941

463

115300

1000

X50

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Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased No

200 Each 29.0000 50 50



washer

YH 10/09/29

D3566-13 Manufactured No

200 Each 26.0000 1



Gasket

YH 10/09/29

D3566-5 Manufactured No

200 Each 30.0000 1



Gasket

YH 10/09/29

D3566-1 Manufactured No

200 Each 19.0000 2



Gasket

YH 10/09/29

Location

Loc Qty

Loc Code

ST245

29

1115698

X50

107534

29

1

Location

Loc Qty

Loc Code

FP012

26

X1

59661

18

60209

8

1

Location

Loc Qty

Loc Code

FP

22

X1

60869

22

FP015

8

59158

8

2

Location

Loc Qty

Loc Code

FP

5

1361656

V2

60857

5

FP015

14

57715

2

60202

12

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Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

D3564-11  
Wearshoe

Manufactured No

200

Each

4.0000

1

1



10/09/29

Location

Loc Qty

Loc Code

FP019

4

B60302

X1

59941

4

D3564-13  
Wearshoe

Manufactured No

200

Each

23.0000

1

1



10/09/29

Location

Loc Qty

Loc Code

FP17

23

59660

11

60862

12

X1

D3564-9  
Wearshoe

Manufactured No

200

Each

20.0000

1

1



10/09/29

Location

Loc Qty

Loc Code

FP

1

55334

1

FP019

19

59201

6

60236

13

X1

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Parent Item Name: Replacement Skidtube

Start Date: 8/19/10

Required Date: 9/06/10

Start Qty: 1.00

Required Qty: 1.00

D3564-5

Manufactured No

200

Each

21.0000

1

1



HL 10/09/29

Wearshoe

Location	Loc Qty	Loc Code
FG	1	
34806	1	
FP19	2	
57525	1	
58709	1	
FP-19	18	
59157	6	
60868	12	

X1

D2594-3

Manufactured No

200

Each

275.0000

16

16



HL 10/09/29

O-Ring, 205 Skidtube

Location	Loc Qty	Loc Code
FP	275	M61762
55546	19	
58191	12	
59358	244	

X16

D2594-1

Manufactured No

200

Each

355.0000

16

16



HL 10/09/29

Plug, 205 Skidtube

Location	Loc Qty	Loc Code
FP	183	1361932
42807	112	
55002	71	
FP14	172	
58434	15	
59110	157	

X16

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2580	REV. D SHEET 1 OF 3
DATE 07.02.27		TITLE 205 SKIDTUBE ASSEMBLY SCALE NTS	
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.26	REDRAWN, INCLUDED DEO 9094/9097	
D	07.02.27	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124/9183	

**RELEASED**  
07-06-28 *[Signature]*

QTY -041	QTY -045	Part Number	Description
X		D2580-041	SKIDTUBE ASSEMBLY
	X	D2580-045	SKIDTUBE ASSEMBLY
1	1	D2500-1-190	EXTRUSION
1	1	D2576-3	STEP
20	24	D2579	CROSS BOLT SPACER
16	16	D2594-1	PLUG
16	16	D2594-3	O-RING
1	1	D2596	205 WEB
1	1	D2855	AFT CAP
1	1	D3564-5	WEARSHOE
1	1	D3564-9	WEARSHOE
1	1	D3564-11	WEARSHOE
1	1	D3564-13	WEARSHOE
2	2	D3566-1	GASKET
1	1	D3566-5	GASKET
1	1	D3566-13	GASKET
50	50	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
50	50	AN3C4A	BOLT
2	2	AN3-5A	BOLT
50	50	AN960C10L	WASHER
2	2	AN960JD10L	WASHER

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NO. 61352

C210/8119

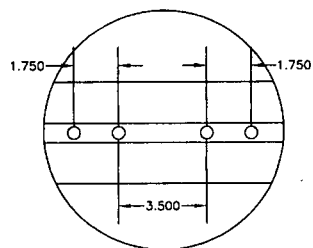
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2596 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-205 TO LOCATE AND DRILL Ø0.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (50 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
SEE NOTES ON  
PAGE 2 FOR D2580-041 AND  
PAGE 3 FOR D2580-045
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

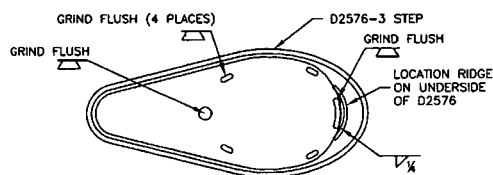
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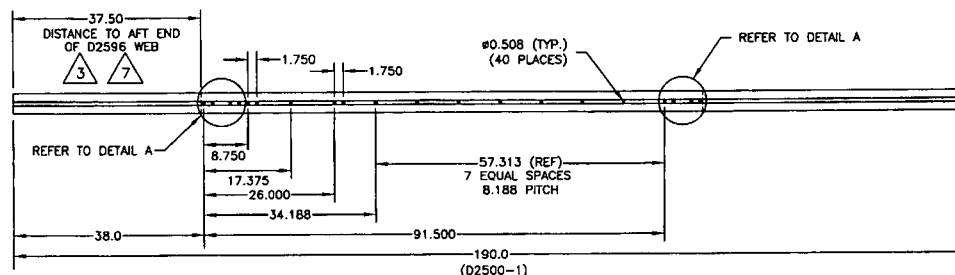
**DETAIL A**  
SCALE 5:24



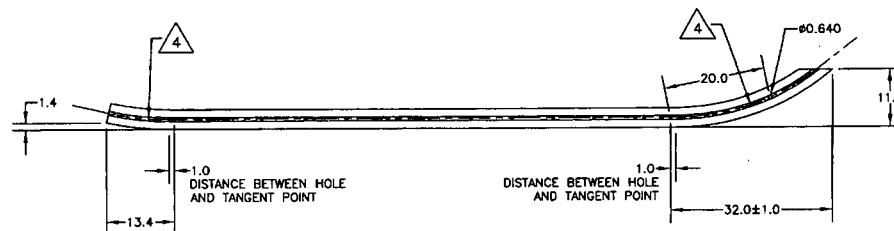
**DETAIL B**  
SCALE 5:24



**D2580-1 DRILLING DETAIL**

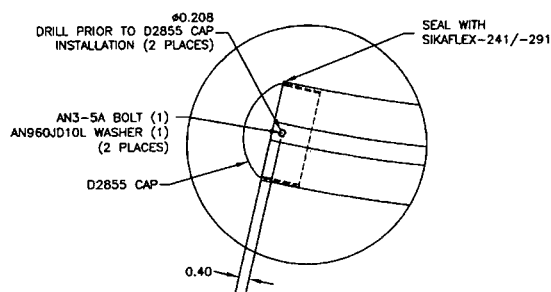


**D2580-1 BENDING AND CUTTING DETAIL**



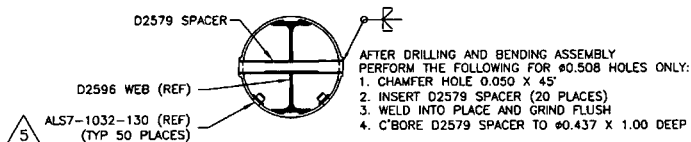
**RELEASED**  
07 Dec 28

**DETAIL C**  
SCALE 5:24

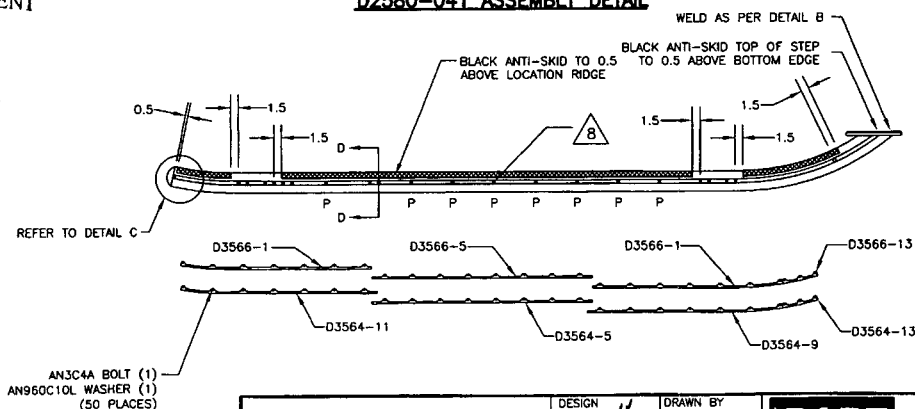


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WORK ORDER  
NO. 61352

**SECTION D-D**  
SCALE 5:24



**D2580-041 ASSEMBLY DETAIL**



**D2580-041 NOTES**

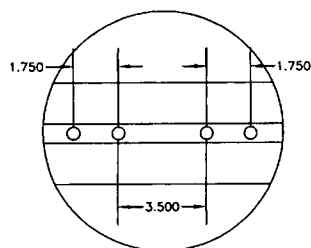
- i) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4

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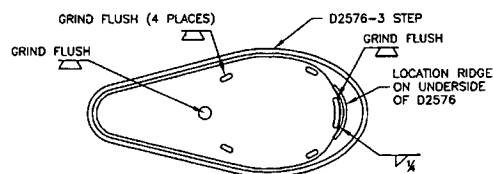
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CHECKED	APPROVED	DRAWING NO.	REV. D
DATE	07.02.27	D2580	SHEET 2 OF 3
		TITLE	SCALE
		205 SKIDTUBE ASSEMBLY	1:24

**DETAIL E**  
SCALE 5:24

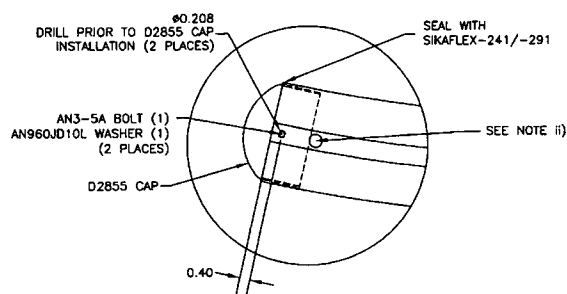


**DETAIL F**  
SCALE 5:24



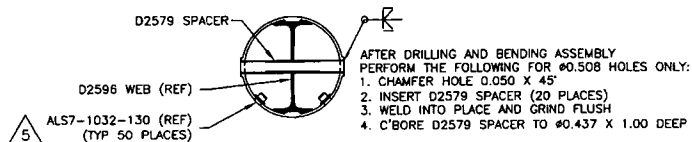
**RELEASED**  
07.06.28

**DETAIL G**  
SCALE 5:24

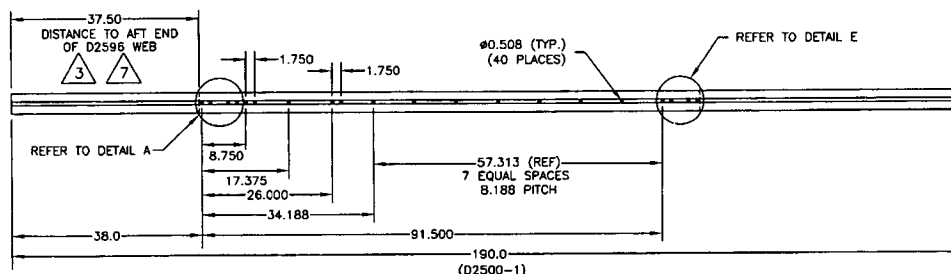


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WORK ORDER  
61352

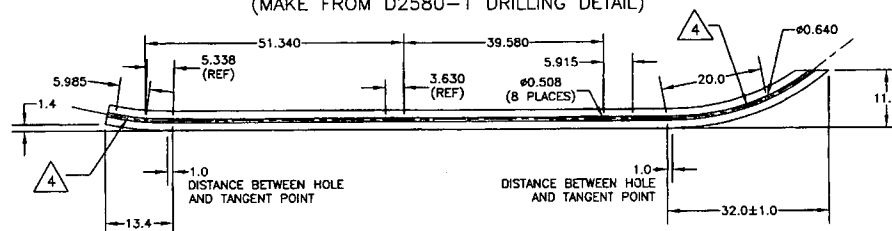
**SECTION H-H**  
SCALE 5:24



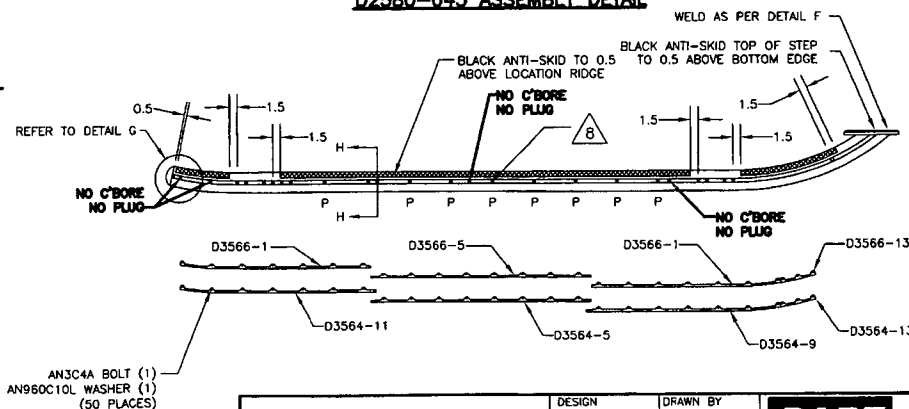
**D2580-1 DRILLING DETAIL**



**D2580-5 BENDING AND CUTTING DETAIL**  
(MAKE FROM D2580-1 DRILLING DETAIL)



**D2580-045 ASSEMBLY DETAIL**



**D2580-045 NOTES**

- FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ENTIRE ASSEMBLY GREEN (REF. 4.3.5.8) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- IT IS ACCEPTABLE TO GRIND A RELIEF IN THE D2855 AFT CAP TO PREVENT INTERFERENCE WITH THE SPACER AT THIS LOCATION

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DESIGN RH	DRAWN BY RH	<b>DART</b>	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED H	APPROVED H	DRAWING NO. D2580	REV. D SHEET 3 OF 3
DATE 07.02.27	TITLE 205 SKIDTUBE ASSEMBLY	SCALE 1:24	



NO. 238

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 61352  
Part number: D205-634-041  
Description: 205 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier P. D. Del Date of Test Coupon 10.08.25  
Welder Barclay Elliott Date of Test Coupon 10.09.25

The above named individual is qualified in accordance with AWS D17.1.2001 to weld